

Work Order ID 113302

113302

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September-16-14 12:38:48 PM

Item ID: D4355-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 2/12/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 2/12/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4355	B

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO 25836
 Cut Blank per D4355-1 file

0.00

CR 14/09/18 3

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

P 14/10/01 (3)

115

QC6- Inspect dimensions to drawing

0.00

115

QC

Quality Control

Memo

0.00

OK 15/01/05

PTO
 →

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 Required Date: 2/12/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	HAAS CNC VERTICAL MACHINING #1					<u>1</u>	<u>2</u>		JFL 2014-12-14
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB049 and Dwg FOLIO REV: <u>AA</u> DWG REV: <u>13</u> 3-Deburr								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						<u>1</u>	<u>2</u>		JFL 2014-12-14
QC	Memo	0.00							
Quality Control									
150	QC8- Inspect parts - second check	0.00							
150						<u>1</u>	<u>0</u>		DAS 08 9-86
QC	Memo	0.00							
Quality Control									

HA 14/12/23

Picklist Print

Page 1

February-12-14 9:53:51 AM

Work Order ID: 113302
 Parent Item: D4355-1
 Parent Item Name: Bearpaw

Start Date: 2/12/14 Required Date: 2/12/14
 Start Qty: 3.00 Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10		Purchased	No			120	sf	281.7082	5.3	16.736842			
UHMW 1" Black - 48"x120"													
Tivar Mfg.#52480104													

Location	Loc Qty	Loc Code
MAT018	281.7082	
121278	9.6282	
122575	47.6	
123229	53	
123949	6.96	
124758	17.52	
m128011	147	

m130421

x16.8

PT07

DQA:

Date:

15/06/05

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

15/06/03

Work Order update only ☐

Work Order: <u>113302</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4355-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5051</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☒	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	☒								
Equip/Tooling									
Handling/Pre									
Material	☒	2014-12-18	130	2		blank is rev A with rad 2.0		14-12-19	
Operator						part 95 rev b with rad 1.0		DAS 9 9-89	
Offset/Setup						Re. Design w/ updates			
Process						correctly 3014-12-18			
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

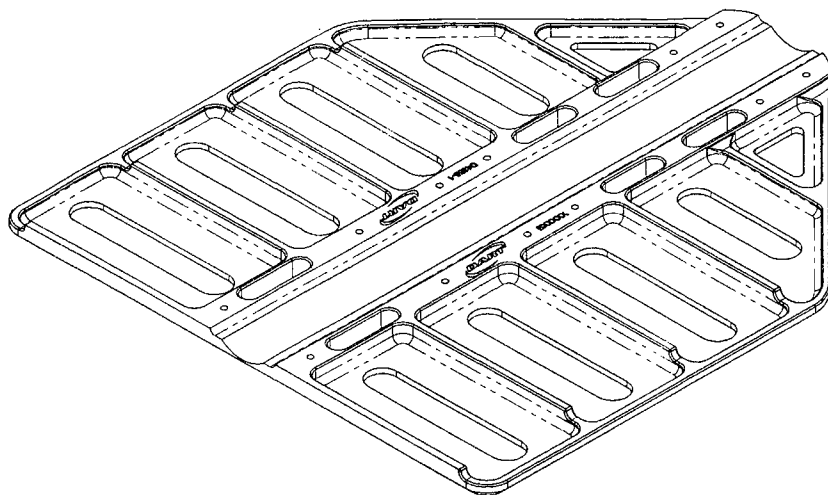
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☒ Outside Dimensions ☒ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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260
1236

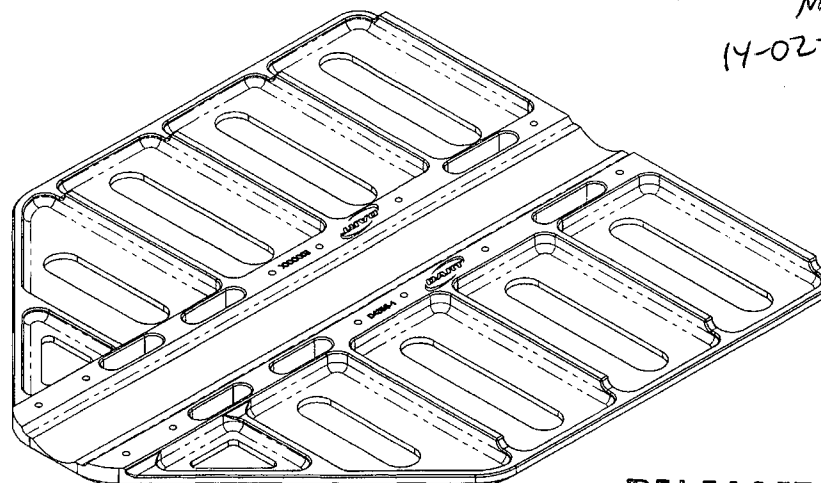
FIRST ARTICLE INSPECTION CHECKLIST

Measured by: JFL		Audited by: J.E. DAS		Preliminary Approval:	
Date: 2014-12-18		Date: 14/12/23		Date:	

Rev	Date	Change	Revised by	Approved
A	12.07.31	New Issue	KJ	



D4355-1 206L/407 BEARPAW



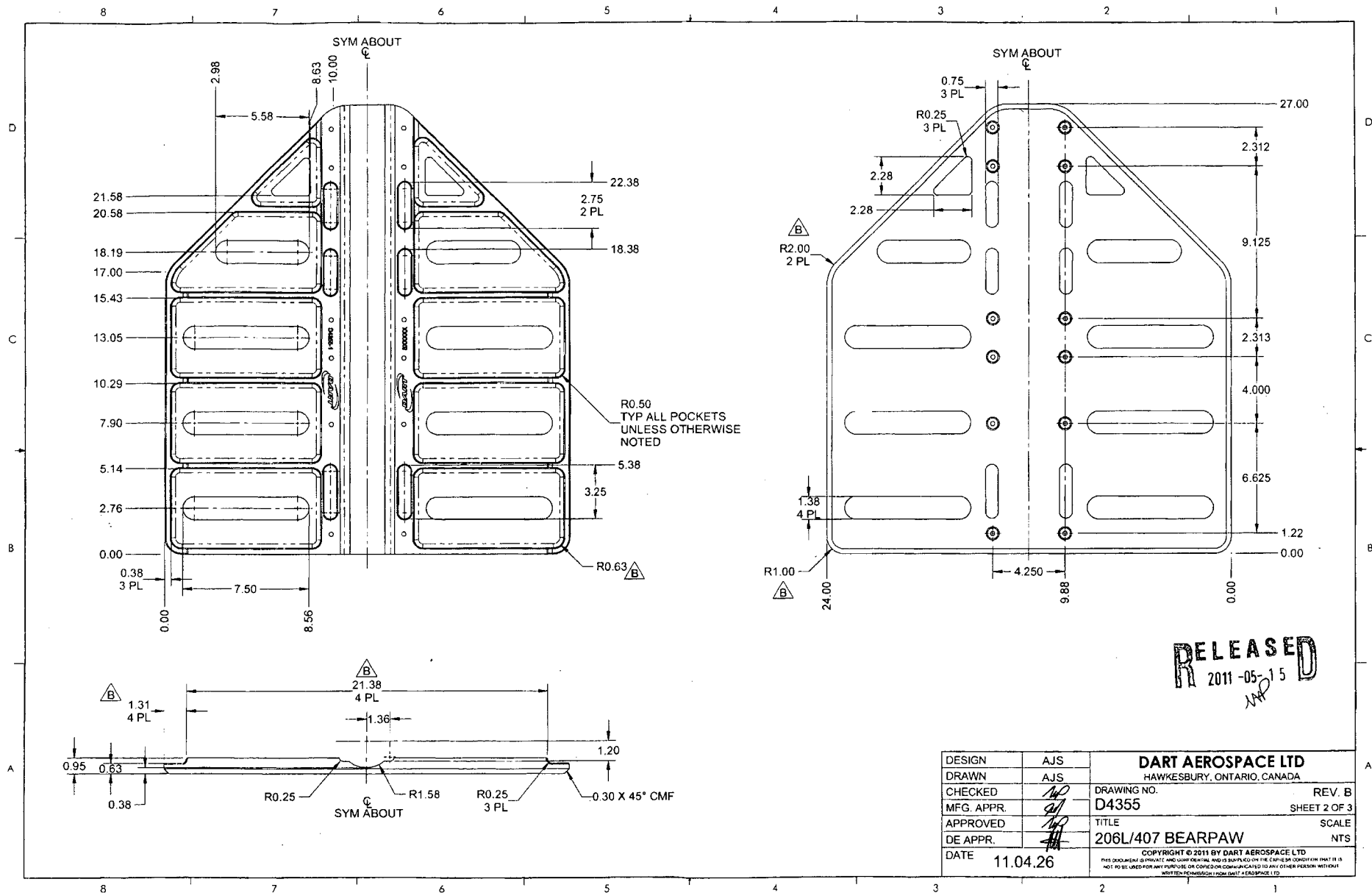
113302
MLJ
14-02-13

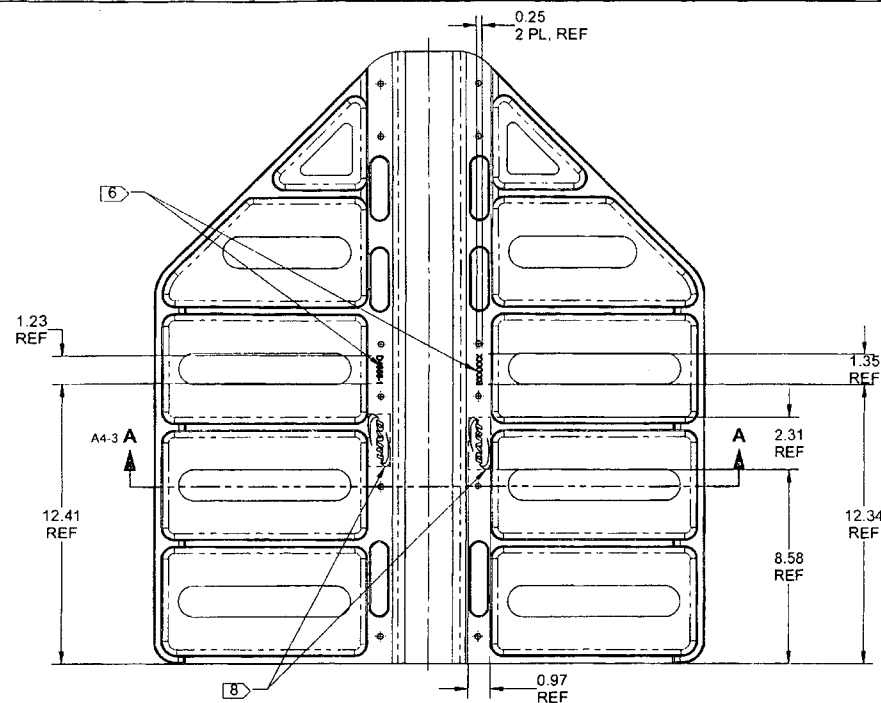
RELEASED
2011-05-10

NOTES:

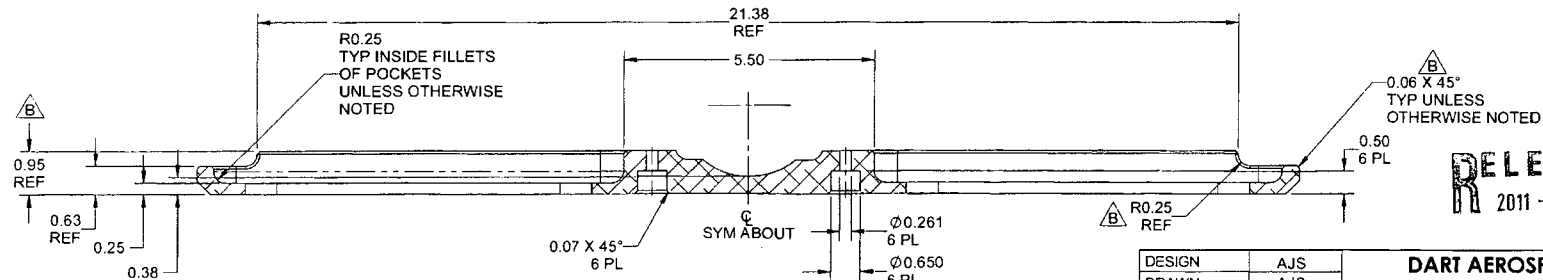
- 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX"
0.010 - 0.012 DP AS SHOWN
- 7) WEIGHT: 6.88 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B		SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. ZN B4 RAD WAS 2.00. SHT 3, SECT. B-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.	AJS	11.04.26
A	NEW ISSUE		AJS	11.03.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D4355	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		206L/407 BEARPAW	NTS	
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		





(SUPPLEMENTAL VIEW)



SECTION A-A
SCALE 2X

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4355	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L/407 BEARPAW	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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RELEASED
2011-05-15

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6316
Date: 2014-09-29
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2
		po 25938	
Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			